

Work Order ID 58699

May 17, 2010 10:32:40 AM

Page 1

Item ID: D3463-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Drag Arm

Start Date: 5/17/10 Start Qty: 12.00

Cust Item ID:

Required Date: 5/19/10 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1-Cut to 13.875"
2-Deburr
3-Bend end as per dwg D3463

SAD 10-05-21

12

110

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

SAD 10/05/21

12

120

0.00



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

1-Mill as per dwg D3463
2-Drill hole & ream to 0.4385" as per dwg D3463
3-Deburr

on 10/05/24

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58699

May 17, 2010 10:32:40 AM



Page 2

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Drag Arm

Start Date: 5/17/10 Start Qty: 12.00



Cust Item ID:

Required Date: 5/19/10 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

encl 10/05/24

12

0

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

A.A 10/05/24

12

0

Quality Control

150

Small Fab

0.00



Small Fab

Memo

0.00

=> m.f 10/05/25

(12x)

Small Fab

Grind .450" rad

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58699

May 17, 2010 10:32:41 AM



Page 3

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Drag Arm

Start Date: 5/17/10

Start Qty: 12.00



Cust Item ID:

Required Date: 5/19/10

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/05-125

462

170

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

PL 10-5-25 (712)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25 (12)
PL 10-5-25 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 17, 2010 10:32:39 AM

Page 1

Work Order ID: 58699



Parent Item: D3463-7



Parent Item Name: Drag Arm

Start Date: 5/17/10

Required Date: 5/19/10

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	0.0000	1.15625			



304 ss round tube .750 x .120w



SAD 10-05-21

M114077 x2

M114706 x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

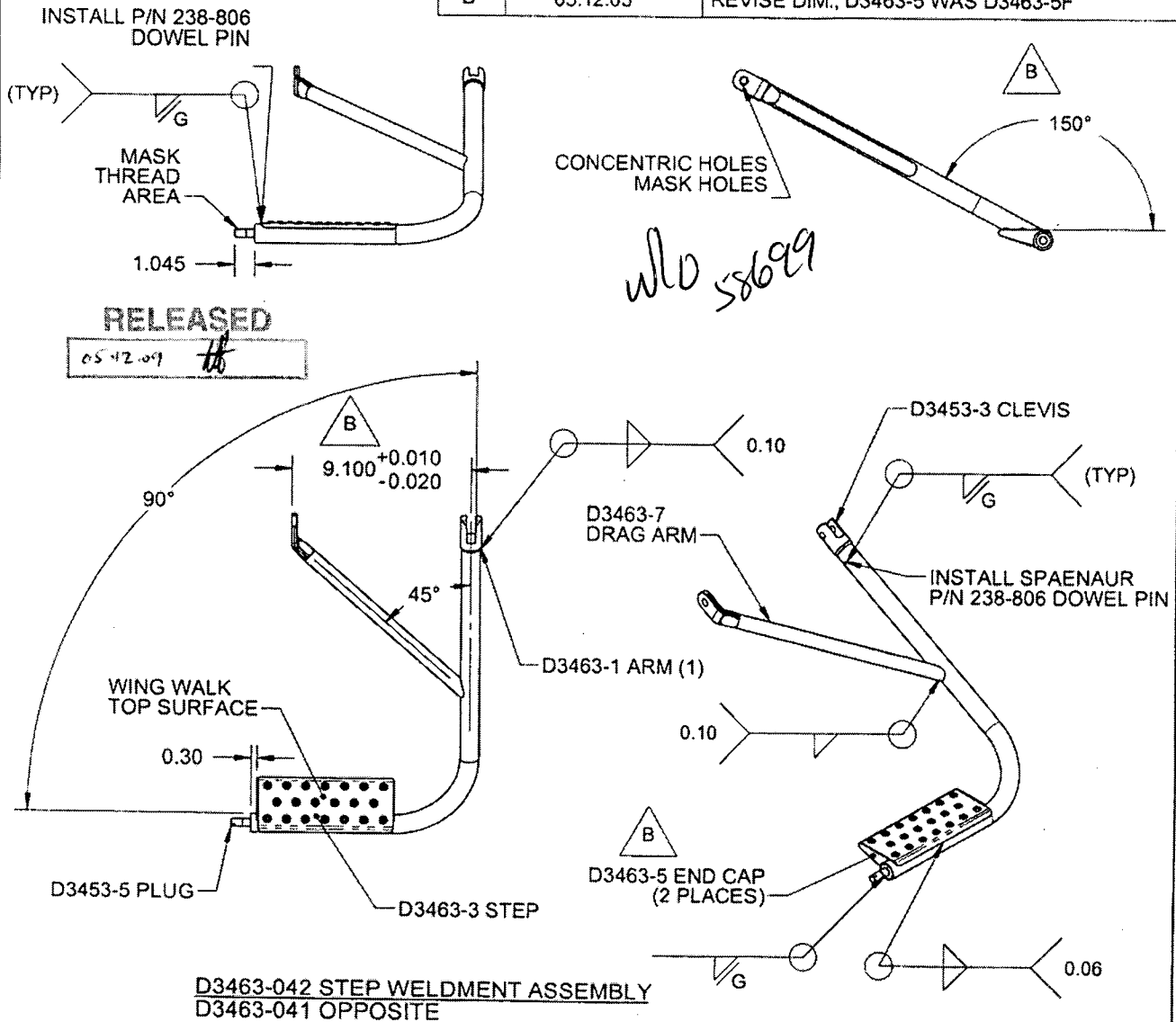
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D3463	
DATE 05.12.05		TITLE STEP WELDMENT		REV. B SHEET 1 OF 4 SCALE 1:8	
A	05.09.20	NEW ISSUE			
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F			



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

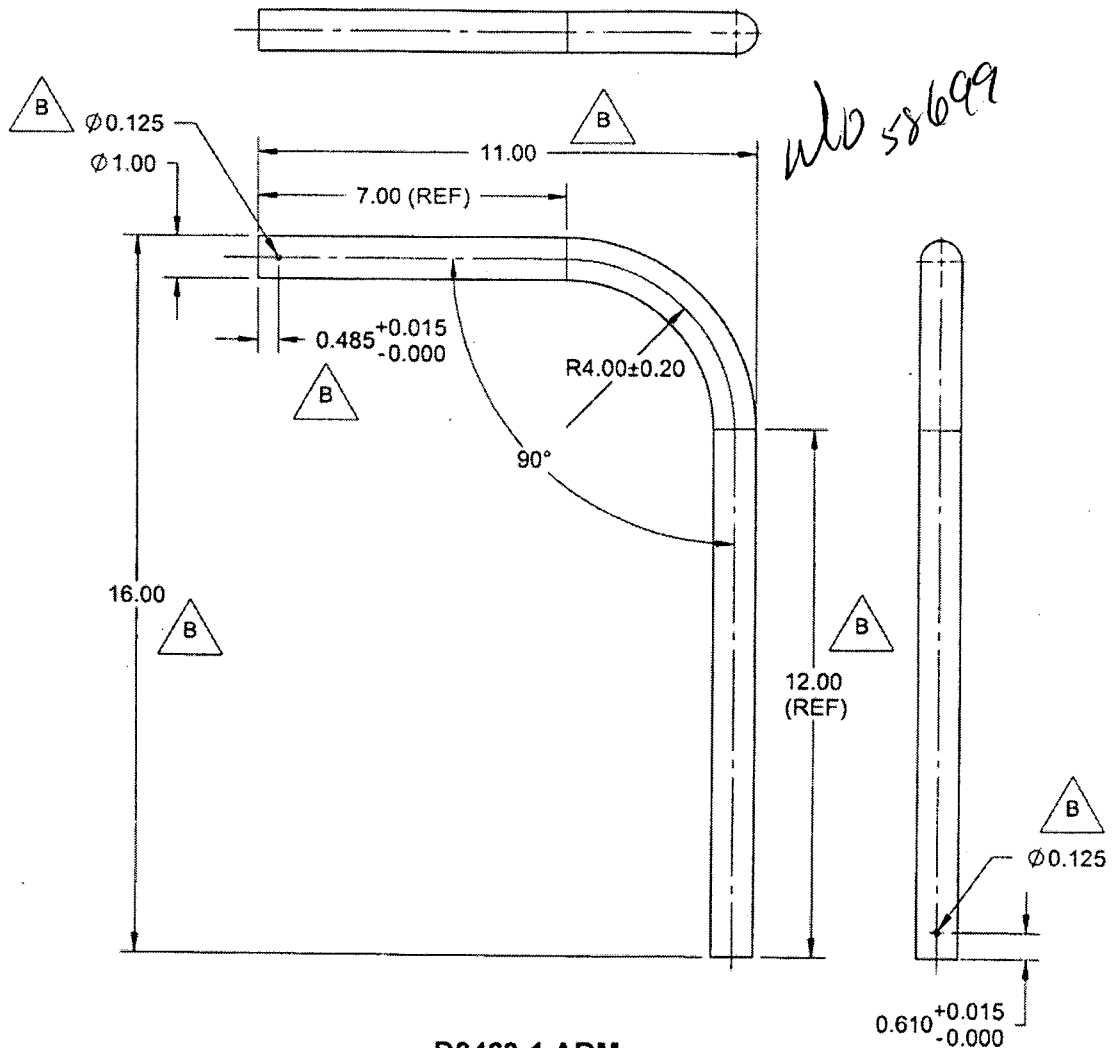
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4



RELEASED

05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

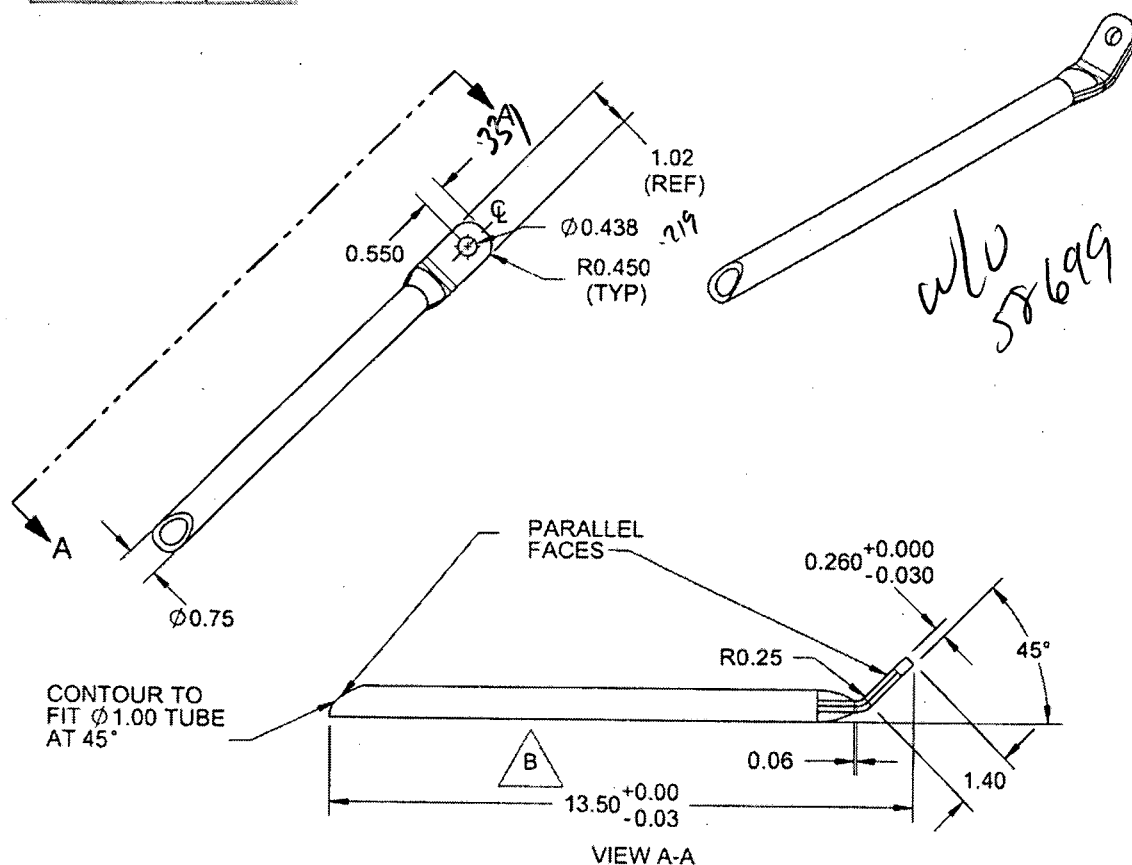
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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DATE 05.12.05		TITLE STEP WELDMENT SCALE 1:4	

05.12.04



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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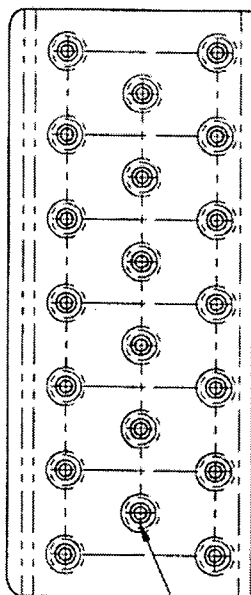
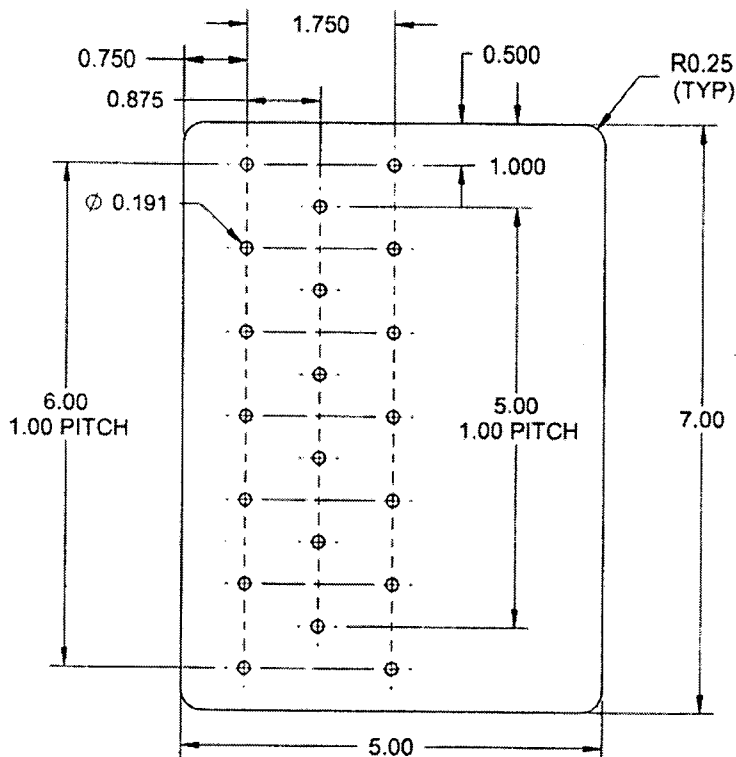
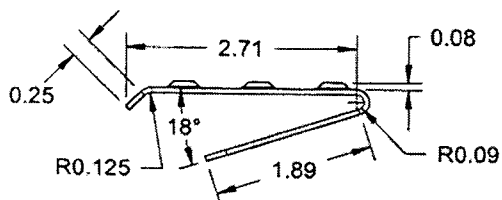
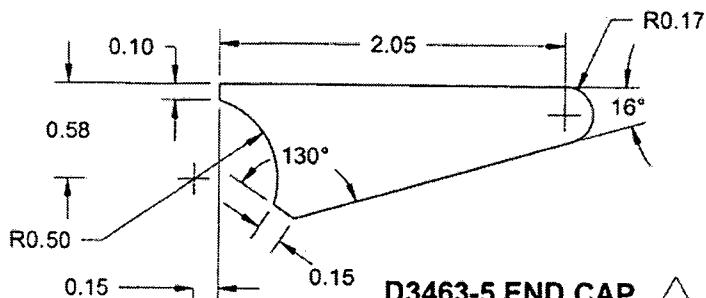
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.09 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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